

# Work Order ID 140353

Tuesday, December 22, 2015 3:10:15 PM

**\*140353\***

*Jan 18*

Page 1

Item ID: D350-591-312

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: ME Date: 12-22-2015 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                        | Set Up/<br>Run Hours | Tool ID          | Tool #. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------------------------------------------|----------------------|------------------|---------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                                                             |                      |                  |         |              |               |               |                  |                |
| D3272                          | Rev B                                                                           |                      | DAS<br>6<br>9-89 |         |              |               |               |                  |                |
| 100                            | Document Control                                                                | 0.00                 |                  |         |              |               |               |                  |                |
| <b>*100*</b>                   | DOCUMENT CONTROL                                                                |                      |                  |         |              |               |               |                  |                |
| DC                             | Memo                                                                            | 0.00                 |                  |         |              |               |               |                  |                |
| Doc.Control -USB or Paperwork  | Photocopy bluefile and type labels as per PPP D350-591-312 CHG001               |                      |                  |         |              |               |               |                  |                |
| 110                            | Large Fab                                                                       | 0.00                 |                  |         |              |               |               |                  |                |
| <b>*110*</b>                   | Large Fab                                                                       |                      |                  |         |              |               |               |                  |                |
| Large Fab                      | Memo                                                                            | 0.07                 |                  |         |              |               |               |                  |                |
| Large Fab                      | 1-Bevel end for welding FWD ONLY                                                |                      |                  |         |              |               |               |                  |                |
|                                | 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272 |                      |                  |         |              |               |               |                  |                |
|                                | A/R Aluminum Rod <u>M32917/M31562</u>                                           |                      |                  |         |              |               |               |                  |                |
|                                | 3-Grind End Plate flush                                                         |                      |                  |         |              |               |               |                  |                |

*MCS 16-01-14*

*10x*

*DAS  
28  
9-89*

*JAN 14 2016*

*10*

*10*

*8*

*BE 16-01-07*

**Work Order ID 140353****\*140353\***

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

(10)

16-01-09

DAS  
9  
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

(10)

16-01-09

DAS  
9  
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.07

Hand Finishing

X10R11 of 11 16-01-09

*Tuesday, December 22, 2015 3:10:15 PM*

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**\*N900040100\***

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**Start Date:** 12/22/2015    **Start Qty:** 10.00    **\*10\***

**Cust Item ID:**

**Required Date:** 1/8/2016      **Req'd Qty:** 10.00      **\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150 QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

0.00

QC

## Memo

## Quality Control

180

0.00

**\*180\***

## Large Fab

0.07

Large Fab

## Memo

## Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 7131562

### 6-Grind End Plate flush

7-Install last rivet as per Dwg.



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**\*NR1\***

Stop

**\*NR2\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description                             | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220                            | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*220*</b>                   | <i>133714.</i>                                       |                      |         |        |              | <i>10</i>     | <i>0</i>      | <i>16-01-13.</i> | <i>33 34 8</i> |
| Powdercoat                     | Memo                                                 | 0.04                 |         |        |              |               |               |                  |                |
| Powder Coating                 | START TIME: <i>10:45</i>                             |                      |         |        |              |               |               |                  |                |
|                                | OVEN TEMPERATURE: <i>320°</i>                        |                      |         |        |              |               |               |                  |                |
|                                | FINISH TIME: <i>11:15</i>                            |                      |         |        |              |               |               |                  |                |
| 230                            | Wing Walk as per dwg QSI005 4.4 Batch <i>M133570</i> |                      |         |        |              |               |               |                  |                |
| <b>*230*</b>                   |                                                      |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo                                                 | 0.04                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |                                                      |                      |         |        |              |               |               |                  |                |
| 240                            | QC3- Inspect Part Finish                             | 0.00                 |         |        |              |               |               |                  |                |
| <b>*240*</b>                   |                                                      |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                 | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                      |                      |         |        |              |               |               |                  |                |

*x10 RH d Hl 16/01/13*

*(10)*

DAS  
38  
JAN 15 2016

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**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

250

## Pick Kit

0.00

**\*250\***

## Memo

0.00

## Packaging

## Packaging

10 DAS 27 JAN 14 2016  
6 9-89

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

## Memo

0.01

OC

## Quality Control

8-88 10 DAS 28 9-89 JAN 14 2016

270

## Packaging

0.00

**\*270\***

## Memo

0.00

### Packaging

### Packaging

Identify and pack for shipping as per PPPD350-591-312  
Location :FG072

DAS  
 27  
 9-89

JAN 18 2016

DAS  
 28  
 9-89

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**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.02

Quality Control

MCS JAN 18 2016

MCS JAN 18 2016

# Picklist Print

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Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3272-1

Manufactured

No

110

Each

0.0000

1

10

**\*D3272-1\***

\*\*

Step

D3067-1

Manufactured

No

110

Each

15.0000

1

10

**\*D3067-1\***

\*\*

End Plate

### Location

### Loc Qty

### Loc Code

WA003

15

136692

1

136944

14

D3219-1

Manufactured

No

110

Each

37.0000

2

20

**\*D3219-1\***

\*\*

Plate

### Location

### Loc Qty

### Loc Code

WA003

37

138871

37

D3066-1

Manufactured

No

180

Each

8.0000

2

20

**\*D3066-1\***

\*\*

Spacer

### Location

### Loc Qty

### Loc Code

WA003

8

138018

8

139086

BE16-01-06  
B140356 x10

BE16-01-06  
B 139635 x10

BE16-01-06  
B140359 x4

16  
16-1-11

8  
12



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Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

218.0000

16

160

**\*MS20600-AD4W4\***

Rivets

\*\*

DP 16-1-11

Location

Loc Qty

Loc Code

ST308

133790

204

M132640

204

WA003

14

M132256

14

D3065-041

Manufactured

No

180

Each

34.0000

1

10

**\*D3065-041\***

Step Leg Assembly

\*\*

DP 16-1-11

Location

Loc Qty

Loc Code

WA002

34

138014

10

138914

24

D3067-1

Manufactured

No

180

Each

15.0000

1

10

**\*D3067-1\***

End Plate

\*\*

BE 16-01-11  
B 139635 v 7

Location

Loc Qty

Loc Code

WA003

15

136692

1

136944

14

AN3-35A

Purchased

No

250

Each

60.0000

2

20

**\*AN3-35A\***

Bolt

\*\*

JAN 14 2016

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

50

m133363

2

m133577

48

DAS  
28  
9-89

20

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Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

D3235-1      Manufactured      No      250      Each      97.0000      2      20

**\*D3235-1\***

Mounting Lug

**\*\***

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST521    | 95      |          |
| 108670   | 13      |          |
| 137133   | 32      | 20       |
| 138591   | 50      |          |
| ST539A   | 2       |          |
| 116383   | 2       |          |

DAS  
28  
9-89

DAS  
27  
9-89

D3278-041      Manufactured      No      250      Each      36.0000      1      10

**\*D3278-041\***

Support Assembly

**\*\***

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST522    | 36      |          |
| 138012   | 16      |          |
| 138878   | 20      | 0        |

DAS  
28  
9-89

DAS  
6  
9-89

DAS  
27  
9-89

JAN 14 2016

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Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0463J

Purchased

No

250

Each

2,708.000

16

160

**\*NAS1149D0463.J\***

WASHER

**\*\***

DAS  
27  
9-89

JAN 14 2016

DAS  
28  
9-89

Location

Loc Qty

Loc Code

|         |      |     |
|---------|------|-----|
| GA      | 432  |     |
| M129390 | 41   |     |
| M132035 | 391  |     |
| ST263   | 852  |     |
| M133284 | 32   |     |
| M133316 | 820  | 160 |
| ST269   | 1424 |     |
| M129682 | 39   |     |
| M130799 | 361  |     |
| M132317 | 101  |     |
| M132677 | 888  |     |
| M133077 | 35   |     |

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Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

1,211.000

4

40

**\*NAS1149D0563J\***

Washer

\*\*

DAS

6

9-89

27

DAS  
28  
9-89

Location

Loc Qty

Loc Code

GA 53

m125807 53

ST260a 520

m130799 55

m132035 55

m132256 10

m133769 400

ST263 463

m133134 129

m133363 334

ST269 156

m128257 156

ST271 19

m131026 19

AN5-36A

Purchased

No

250

Each

39.0000

2

20

**\*AN5-36A\***

Bolt

\*\*

3 x M133990

DAS

6

9-89

DAS

27

9-89

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST299A 1

M131957 1

ST336 15

M130466 15

ST399a 23

M133577 23

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Start Date: 12/22/2015

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Start Qty: 10.00

Required Qty: 10.00

D2618

Manufactured No

250

Each

77.0000

2

20

DAS

6

9-89

DAS

6

9-89

**\*D2618\***

Bushing

\*\*

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST008A

15

137715

15

ST012a

62

138990

20

139586

42

13

7

D2230-3

Manufactured No

250

Each

152.0000

4

40

DAS

6

9-89

DAS

6

9-89

**\*D2230-3\***

Mounting Lug

\*\*

DAS  
28  
9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

64

132403

24

138587

40

ST525A

80

137522

80

20

20

D2856-400

Manufactured No

250

f

174.6000

1.2

12

DAS

6

9-89

DAS

6

9-89

**\*D2856-400\***

Abrasion Strip 4" Wide (Per Foot)

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST418

174.6

134509

174.6

12

cut (2) D2856-400-720 as per dwg

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Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

1,697.000

2

20

**\*MS21042L3\***

Nut

**\*\***

DAS 27  
6 9-89

Location

Loc Qty

Loc Code

FP001

185

m133790

185

GA

232

m133790

232

ST304

1280

m133790

1280

20

AN4-13A

Purchased

No

250

Each

174.0000

8

80

**\*AN4-13A\***

Bolt

**\*\***

DAS 27  
6 9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

ST344

154

m133769

154

80

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Start Qty: 10.00

Required Qty: 10.00

MS21042L5 Purchased No 250 Each 570.0000 2 20

**\*MS21042L5\***

Nut

**\*\***

DAS

6

DAS

27

9-89

JAN 14 2016

Location

Loc Qty

Loc Code

|         |     |    |
|---------|-----|----|
| GA      | 146 |    |
| m127813 | 146 |    |
| ST303   | 300 |    |
| m133577 | 200 | 20 |
| m133790 | 100 |    |
| ST304   | 76  |    |
| m133363 | 76  |    |
| ST305   | 48  |    |
| m127813 | 19  |    |
| m131340 | 21  |    |
| m132123 | 8   |    |

DAS  
28  
9-89

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**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

3,083.000

8

80

**\*MS21042L4\***

**\*\***

Locknut

Location

Loc Qty

Loc Code

FP001

137

m133363

137

GA

41

m127813

41

ST260a

92

m130799

56

m132262

36

ST303

2680

m133769

2680

ST305

133

m128300

8

m130388

4

m130922

97

m132123

24

DAS  
28  
9-89

DAS  
6  
9-89

DAS  
27  
9-89

NAS1149D0363J

Purchased

No

250

Each

885.0000

4

40

**\*NAS1149D0363J\***

**\*\***

Washer

Location

Loc Qty

Loc Code

GA

129

m130799

129

ST263

756

m133709

256

m133790

500

DAS  
28  
9-89

JAN 1 1 2016

DAS  
6  
9-89

DAS  
27  
9-89





|                      |                                |                                                          |                        |
|----------------------|--------------------------------|----------------------------------------------------------|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>JB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3272                                     | REV. B<br>SHEET 1 OF 3 |
| DATE<br>07.05.18     |                                | TITLE<br>STEP ASSEMBLY, HI LONG                          | SCALE<br>NTS           |
| A                    | 04.03.01                       | NEW ISSUE                                                |                        |
| B                    | 07.05.18                       | D3272-1 WAS D2622-120                                    |                        |

**RELEASED**

07.06.04 *[Signature]*

| QTY<br>-041 | QTY<br>-042 | PART NUMBER  | DESCRIPTION                   |
|-------------|-------------|--------------|-------------------------------|
| X           |             | D3272-041    | STEP ASSEMBLY, HIGH LONG (LH) |
|             | X           | D3272-042    | STEP ASSEMBLY, HIGH LONG (RH) |
|             |             |              |                               |
| 1           | 1           | D3065-041    | LEG ASSEMBLY                  |
| 2           | 2           | D3066-1      | SPACER                        |
| 2           | 2           | D3067-1      | END PLATE                     |
| 2           | 2           | D3219-1      | SUPPORT                       |
| 1           | 1           | D3272-1      | STEP                          |
|             |             |              |                               |
| 16          | 16          | MS20600AD4W4 | RIVET                         |
|             |             |              |                               |

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

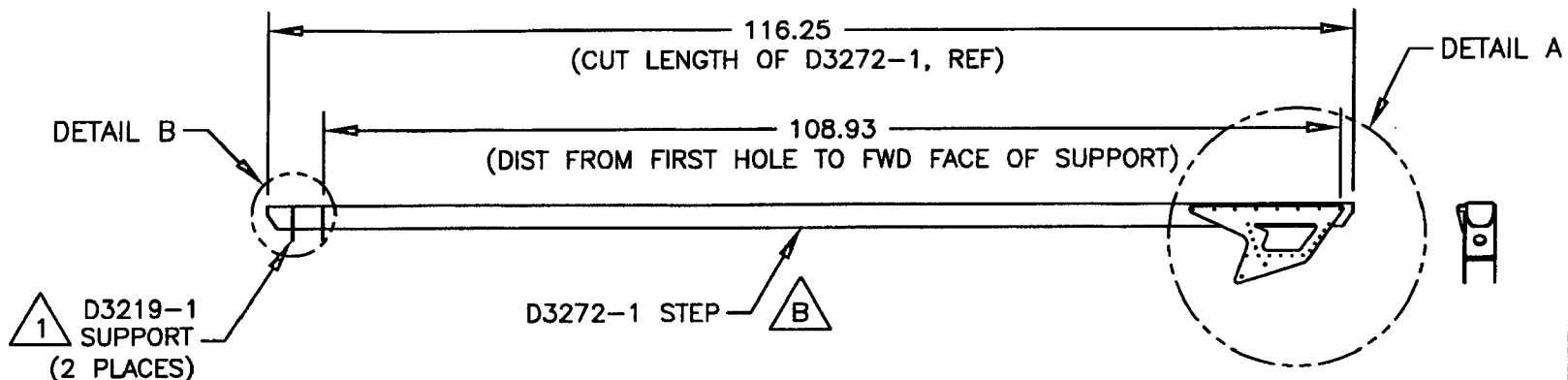
*1/16" 5/32" 1/8" 3/16" 1/4" 3/8" 1/2" 5/8" 3/4" 7/8" 1" 1 1/8" 1 1/4" 1 1/2" 1 3/4" 2" 2 1/4" 2 1/2" 2 3/4" 3" 3 1/4" 3 1/2" 3 3/4" 4" 4 1/4" 4 1/2" 4 3/4" 5" 5 1/4" 5 1/2" 5 3/4" 6" 6 1/4" 6 1/2" 6 3/4" 7" 7 1/4" 7 1/2" 7 3/4" 8" 8 1/4" 8 1/2" 8 3/4" 9" 9 1/4" 9 1/2" 9 3/4" 10"*

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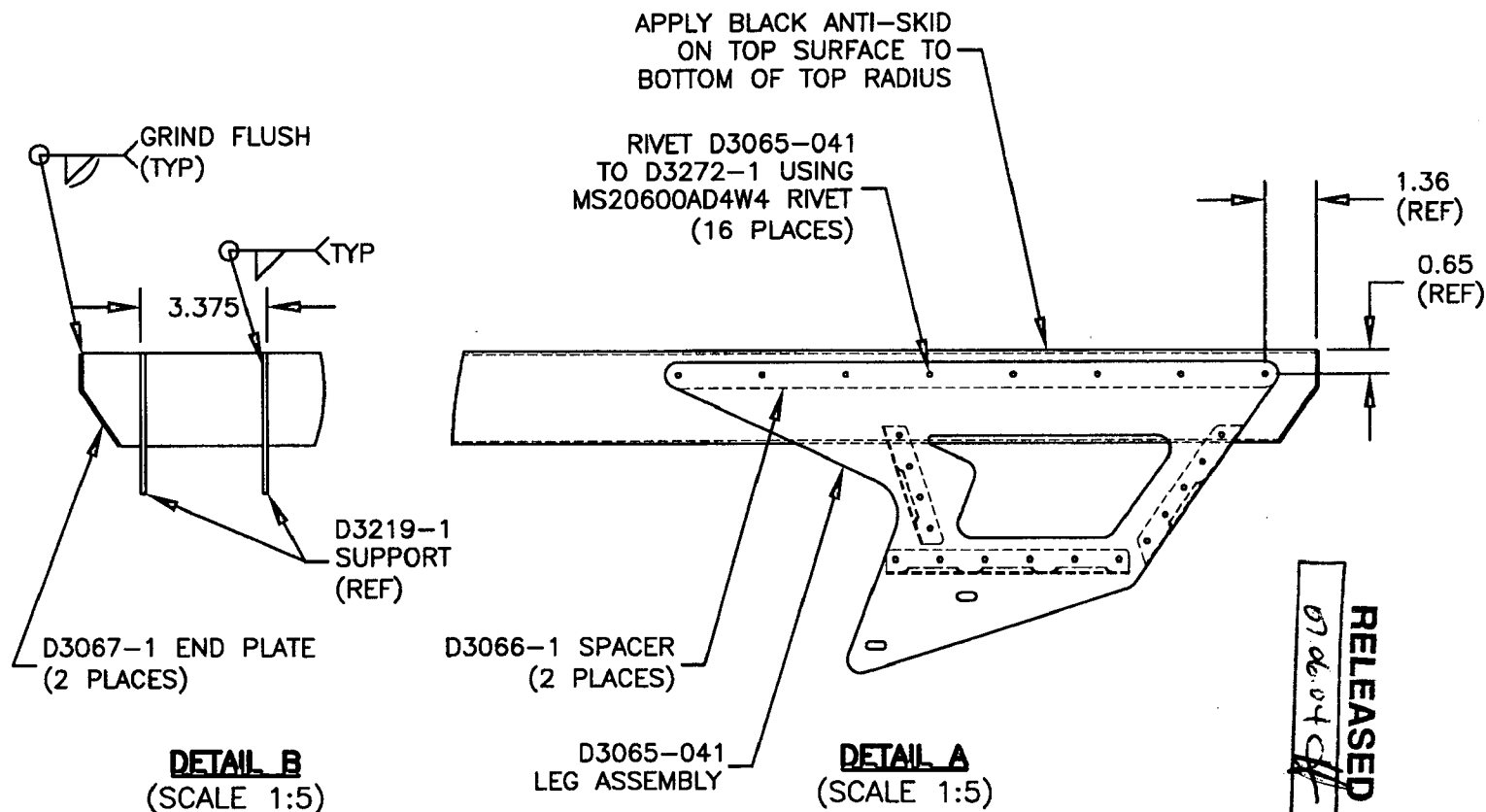
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| DATE    | 07.05.18 | DRAWING NO. | D3272                  | REV. B                      |
|         |          | TITLE       | STEP ASSEMBLY, HI LONG | SHEET 2 OF 3                |
|         |          | SCALE       | 1:20                   |                             |



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



**DETAIL B**  
(SCALE 1:5)

**DETAIL A**  
(SCALE 1:5)

# REFERENCE ONLY

DART AEROSPACE LTD.

DAS  
28  
9-89

D350-591  
Page 23 of 23

| Qty<br>-211 | Qty<br>-212 | Qty<br>-213 | Qty<br>-214 | Qty<br>-215 | Qty<br>-216 | Qty<br>-311 | Qty<br>-312 | Part Number   | Description                                   |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-----------------------------------------------|
| X           |             |             |             |             |             |             |             | D350-591-211  | Heli-Access-Step™, Long Step – High Skid, LH  |
|             | X           |             |             |             |             |             |             | D350-591-212  | Heli-Access-Step™, Long Step – High Skid, RH  |
|             |             | X           |             |             |             |             |             | D350-591-213  | Heli-Access-Step™, Short Step – High Skid, LH |
|             |             |             | X           |             |             |             |             | D350-591-214  | Heli-Access-Step™, Short Step – High Skid, RH |
|             |             |             |             | X           |             |             |             | D350-591-215  | Heli-Access-Step™, Short Step – Low Skid, LH  |
|             |             |             |             |             | X           |             |             | D350-591-216  | Heli-Access-Step™, Short Step – Low Skid, RH  |
|             |             |             |             |             |             | X           |             | D350-591-311  | Heli-Access-Step™, Long Step – High Skid, LH  |
|             |             |             |             |             |             |             | X           | D350-591-312  | Heli-Access-Step™, Long Step – High Skid, RH  |
| 1           |             |             |             |             |             |             |             | D3070-041     | STEP ASSEMBLY (HIGH-LONG, LH)                 |
|             | 1           |             |             |             |             |             |             | D3070-042     | STEP ASSEMBLY (HIGH-LONG, RH)                 |
|             |             | 1           |             |             |             |             |             | D3078-041     | STEP ASSEMBLY (HIGH-SHORT, LH)                |
|             |             |             | 1           |             |             |             |             | D3078-042     | STEP ASSEMBLY (HIGH-SHORT, RH)                |
|             |             |             |             | 1           |             |             |             | D3168-041     | STEP ASSEMBLY (LOW-SHORT, LH)                 |
|             |             |             |             |             | 1           |             |             | D3168-042     | STEP ASSEMBLY (LOW-SHORT, RH)                 |
|             |             |             |             |             |             | 1           |             | D3272-041     | STEP ASSEMBLY (HIGH-LONG, LH)                 |
|             |             |             |             |             |             |             | 1           | D3272-042     | STEP ASSEMBLY (HIGH-LONG, RH)                 |
| 4           | 4           |             |             |             |             |             |             | D2182B035     | RUBBER CUSHION                                |
|             |             | 2           | 2           | 2           | 2           |             |             | D2230-1       | MOUNTING LUG                                  |
|             |             | 2           | 2           | 2           | 2           | 4           | 4           | D2230-3       | MOUNTING LUG                                  |
| 8           | 8           |             |             |             |             |             |             | D2274         | RADIUS BLOCK                                  |
|             |             |             |             |             |             | 2           | 2           | D2618         | BUSHING                                       |
| 4           | 4           | 4           | 4           | 4           | 4           |             |             | D2732-030     | CUSHION                                       |
| 2           | 2           | 1           | 1           | 1           | 1           | 2           | 2           | D2856-400-720 | ABRASION STRIP                                |
| 2           | 2           |             |             |             |             |             |             | D3064-1       | CLAMP                                         |
| 1           | 1           |             |             |             |             |             |             | D3079-041     | SUPPORT ASSEMBLY                              |
| 4           | 4           |             |             |             |             |             |             | D3080-1       | CLAMP                                         |
|             |             |             |             |             |             | 2           | 2           | D3235-1       | MOUNTING LUG                                  |
|             |             |             |             |             |             | 1           | 1           | D3278-041     | SUPPORT ASSEMBLY                              |
| 2           | 2           | 2           | 2           | 2           | 2           | 2           | 2           | AN3-35A       | BOLT                                          |
| 10          | 10          | 2           | 2           | 2           | 2           |             |             | AN4-11A       | BOLT                                          |
|             |             | 4           | 4           | 4           | 4           | 8           | 8           | AN4-13A       | BOLT                                          |
|             |             |             |             |             |             | 2           | 2           | AN5-36A       | BOLT                                          |
| 4           | 4           | 4           | 4           | 4           | 4           | 4           | 4           | AN960JD10     | WASHER                                        |
| 20          | 20          | 12          | 12          | 12          | 12          | 16          | 16          | AN960JD416    | WASHER                                        |
|             |             |             |             |             |             | 4           | 4           | AN960JD516    | WASHER                                        |
| 2           | 2           | 2           | 2           | 2           | 2           | 2           | 2           | MS21042L3     | NUT                                           |
| 10          | 10          | 6           | 6           | 6           | 6           | 8           | 8           | MS21042L4     | NUT                                           |
|             |             |             |             |             |             | 2           | 2           | MS21042L5     | NUT                                           |
|             |             |             |             |             |             | 1           | 1           | *DSI 9410-011 | STEP MODIFICATION KIT                         |

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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\*on work order it's revision B but the only bluefile I found it's Rev. G. ???

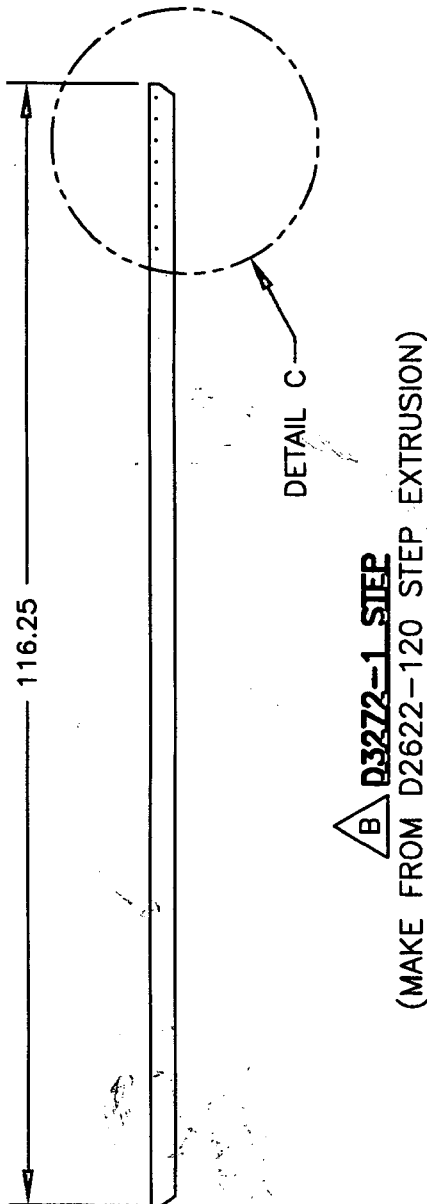
Revision: G  
Date: 08.10.06



|                  |                                 |                                                   |                        |
|------------------|---------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>GP     | DRAWN BY<br>[Signature]         | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>LE    | APPROVED<br>[Signature]         | DRAWING NO.<br>D3272                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>07.05.18 | TITLE<br>STEP ASSEMBLY, HI LONG |                                                   | SCALE<br>1:20          |

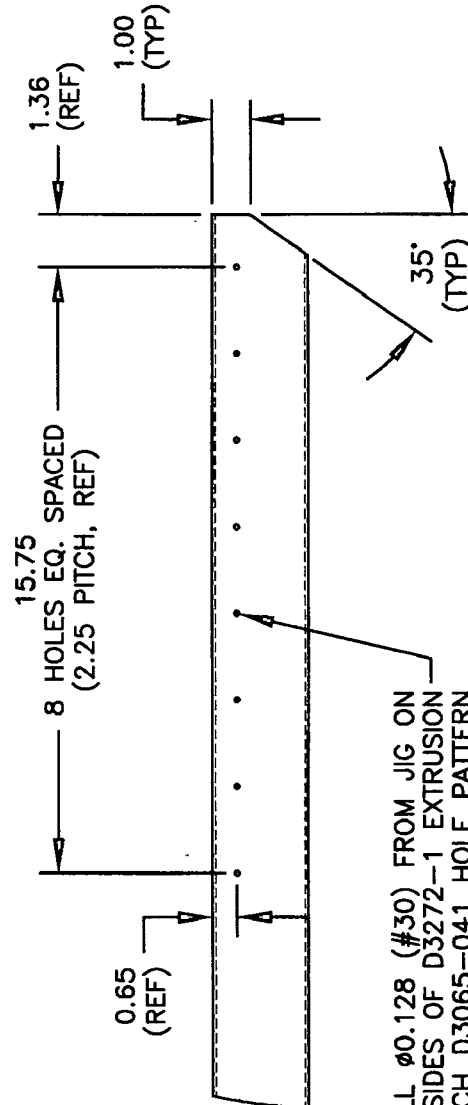
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07.06.04 [Signature]



**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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